

Date:
User:Monday, 3/19/2007 8:13:10 AM
Kim Johnston

Process Sheet

Split

8/3 07/03/30

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BLOWER MOTOR INLET ADAPTER
 Job Number : 31258
 Estimate Number : 12247
 P.O. Number : N/A Part Number : D3477041
 This Issue : 3/19/2007 S.O. No. : N/A Drawing Number : D3477 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : 28518 Material : N/A
 Due Date : 3/23/2007 Qty: 4 Um: Each
 Written By : 07.03.19
 Checked & Approved By : 07.03.19
 Comment : Est Rev: A New Issue 06-02-03 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D34773

Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-3	Tube	<u>B 2267 31403</u>

2.0

D34771

Flange



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-1	Flange	<u>B 2275</u>

3.0

D34775

BLOWER ADAPTER FLANGE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3477-5	Flange	<u>B 31276</u>

4.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3477

2-Spot Weld as per Dwg D3477 and Dart QSI 004

mrf 07-09-11

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR INLET ADAPTER

Job Number: 31258

Part Number: D3477041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: GA

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10/09/11

U 27 29-11

SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 11

EMPLOYEE: Melissa Fairley

PART NUMBER: D3477-041

JOB NUMBER: B 31258

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.18

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	<input checked="" type="checkbox"/>	<input type="checkbox"/>
PENETRATION:	<input checked="" type="checkbox"/>	<input type="checkbox"/>
PULL STRENGTH:	<input checked="" type="checkbox"/>	<input type="checkbox"/>

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/09/11

QUALIFIER: 573

